

# ENGINEERING CHANGE NOTICE

## DART AEROSPACE LTD

85

Date: 08.06.23	Job No.: N/A	ADR Yes/No: N	ADR Date: <i>MP</i>	ECN #: 1206
Product No.: D206-667		Created By: <i>MP</i>	Approved By: <i>MP</i>	
Product Name: Crosstubes		Checked By: <i>MP</i>	General Manager Approval:	

Distribution	Reqd	Resp	Received
Production Manager	X	LL	
Production Engineering Coord			
Director Quality Assurance			
Customer Order Processing			

Distribution	Reqd	Resp	Received
Customer Technical Support			
Marketing			
Quality	X	JM	<i>08.06.24</i>

**Reason for Change:**  
Production drilled crosstube holes on wrong side

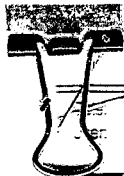
**Documents Affected:**  
Release DSI 9346 Rev. H

#	Engineering Actions	Reqd	Resp	Notes	Complete
1	Required Documents/Drawings Under Review	N			
2	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ	Update to existing files only	<i>08.06.24</i>
3	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		<i>08.06.24</i>
4	Update Grey Project Binder	N			
5	Move Electronic Files	Y	KJ		<i>08.06.24</i>
6	Update Master Document List (MDL) <i>Rev. F</i>	Y	<i>KJ</i>		<i>08.06.24</i>
7	Update Document Record (DR) <i>Rev. M</i>	Y	KJ		<i>08.06.24</i>
8	Create/Update Change Record Form	N			
9	Create/Update PPP's	N			
10	Update Controlled PDF Files	Y	KJ		<i>08.06.24</i>
11	Notify TC/FAA of Change	N			
12	Update QSI 021 and/or STC Approval List	N			
13	Update Product Development Summary	N			
14	Update Accpac Database	N			
15	Update Access (ARC) Database	N			
16	Update/Verify ARC	N			
17	Update Paperwork Kits in Production	Y	LL/KJ	See below	<i>08.06.24</i>
18	Update Qpulse/Laminated Dwgs	N			
19	Update Product Compatability Matrix	N			
20	Create Eurocopter Form (FEE)	N			
21					

#	Production Actions	Reqd	Resp	Notes	Complete
22	Create/Update Coss IPP/BOM	N			
23	Update FAI Sheets	N			
24	Create/Update CNC Programs	N			
25	Create/Update Tooling	N			
26	Red Tag Stock (Specify)	N			
27	Rework/Scrap Current Production and/or Stock	N			
28	Update Paperwork Kits in Stock	Y	LL/KJ	See below	<i>N/A</i>
29	Create/Update MPP	N			
30					

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
31	Notify Previous Customers	N			
32	Notify Eurocopter France	N			
33					

**Description / Action:**  
Add DSI 9346 Rev. H to the following ONLY:  
- D407-667-105 - B39271 - CHG 003  
- D206-667-203 - B39852 - CHG 003



BLUE

Dart Aerospace Ltd.

Friday, 13/06/2008 10:45:15 AM  
Julie Lecocq

## Process Sheet

slp 09/07

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 39852  
Estimate Number : 10973  
P.O. Number :  
This Issue : 13/06/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : // Type : LANDING GEAR  
Previous Run : 34483  
Written By :  
Checked & Approved By : JUD 08.06.13  
Comment : Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM

Drawing Name : 206L AFT X-TUBE  
Part Number : D206667203BL  
Drawing Number : D206-667-243 REV B + DSI 9415 08.06.13  
Project Number : N/A  
Drawing Revision :  
Material :  
Due Date : 30/06/2008 Qty: 1 Um: Each



Additional Product

Please Add  
this tube to  
the DSI for  
the cuff as well

08.06.13 (1)

Job Number:



Seq. #:

Machine Or Operation:

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002 CHG 003 + DSI 9415 08.06.13

2.0 D6004115

Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6004-115 Crosstube

Check OD = 2.500"; ID = 1.800"

3.0 MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

4.0 QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

File: Wednesday, 14/05/2008 3:29:28 PM  
User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 407 FWD X-TUBE
Job Number	: 39271		
Estimate Number	: 12348		
P.O. Number	:	Part Number	: D407667105
This Issue	: 14/05/2008 S.O. No. :	Drawing Number	: D407-667-145 REV B
Print Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : CROSSTUBES	Drawing Revision	: B
Previous Run	: 39110	Material	:
Written By	:	Due Date	: 30/05/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JUL 08.5.14</u>		
Comment	: Est Rev: F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM		

Additional Product

## REFERENCE ONLY

Job Number:



needs to be

added to DSI

Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D407-667-105 CHG 002 003

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0 D407667105TRN CROSSTUBE TURNING DETAIL



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch 839144

EL 8-6-10

4.0 BENDING BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D407-667-145 using CNC bender program 407-fw and Folio FT016

EL 8-6-10

5.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Job 06-10

6.0 CROSSTUBES CROSSTUBES RESOURCE 1

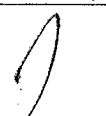
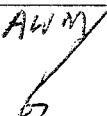




Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 &amp; DT8542 as per Dwg D407-667-145. Drill all (3) top holes.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-06-11	8.0	3 holes drilled on each side of the coll. Employees 1st time drilling this model. R.C. Inadequate instructions from his trainer		Trainer must be more aware and work with the employee being trained. - Add tube to DSI	 8-6-11		 08/06/11	 08/06/11

NOTE: Date & initial all entries